

Date: Tuesday, 10/23/2007 3:10:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ASPIRATOR	
Job Number	: 35321		Part Number	: D2000109	
Estimate Number	: 12424		Drawing Number	: D2000-109 REV A1	
P.O. Number	:		Project Number	: N/A	
This Issue	10/23/2007	S.O. No.	Drawing Revision	: A1	
Prsht Rev.	: NC		Material	:	
First Issue	11	Type	PURCHASED PARTS	Due Date	11/15/2007
Previous Run	: 27400		Qty:	10	Um: Each
Written By	:		Checked & Approved By	: <u>10/23/07</u>	
Comment	: Est Rev:A New Issue 06-05-31 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING
		
Comment: PURCHASING Issue P/O: <u>4889</u> For D2000-109 Spin as per Dwg D2000-109 Possible Supplier: SIEG Material release note is required		
2.0	D2000109S	Aspirator- Outer Flange
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK
		
Comment: DIMENSIONAL CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill as per Dwg D2000 Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 35321

Part Number: D2000109

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8/05/01 (YTD)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(Rox)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 162

8/5/21

SO

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/2001

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Uffn. GERRY



ALCOA WIRE PRODUCTS
1480 Manheim Pike
Lancaster Pa. 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 0000675996

DATE 4/23/2007

SKID NO 661033

SKID WGT 9,885

PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756		MILL FINISH			
ITEM NO	1	PART NO			NON ANODIZE QUALITY			
ALLOY	1100	TEMPER	O	FORM	OUT: STANDARD MILL FINISH			
GAUGE	0.6300	WIDTH	48.0000	LENGTH	IN: STANDARD MILL FINISH NOT EMBOSSED			

LOT: 334171 COIL: B01 DROP: 0710187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
0718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.4 KSI

TAIL ULTIMATE STRENGTH 11.6 KSI

HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI

TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI

HEAD ELONGATION (G.L. = 2 IN) 32 %

TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-95

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF

ASME SB269 1100 C, AMS 4901H 1100 C

ASTM B209-95 1100 O, AMS-QQ-A-250/1 1100 O

FAX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accord, ne with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and test samples representative of the material and its composition. Also, note that mercury is not a normal constituent in aluminum alloys and neither is any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

ALCOA WIRE PRODUCTS, INC. 1480 Manheim Pike, Lancaster, PA 17601
Phone: 717-544-2000 Fax: 717-544-2001

Authorized by:

DEEP KREADY, LAB SUPERVISOR

Order No. 376276

Part:

PO: 38C880

TR clerk signature:



Sieg's Manufacturing Ltd.
6236 205 street, Langley BC, V2Y 1N7
Phone: (604) 530-7455 Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 34575
Date: 11/05/2007
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 4888	Sold By: KAULBARS, GERRY
Shipped By:	Ship Date: 11/06/2007
Tracking No.:	

Item No.	Unit	Description	Quantity
1	EACH	D2000109S OUTER FLANGE	10
2	EACH	D2000111S INNER CORE	10
<i>H1107</i>			
<i>SS</i>			
REFERENCE ONLY			
Comment:			



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Nov. 5/07
Customer: Dart Aerospace
Packing Slip: 34575

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	n/a	✓	KR
D2000111S	10	14G	n/a	✓	KR

7/11/07

S6 Notes:

2 Boxes.

Material Certification Attached: YES

REFERENCE